

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64792

Friday, December 17, 2010 7:55:32 AM

Page 2

Item ID: D3296-041

Accept

Revision ID:

Item Name: Door Assembly

Start Date: 12/16/2010 Start Qty: 6.00

Required Date: 1/19/2011 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10. 11/02/08

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3296

ES 11/02/09 10

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/02/09

10

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Accept

**Setup Start**

Stop

**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID**Tool #**

Plan Code

Accept	Qty
--------	-----

Reject
QtyReject
Number

**Insp.
Stamp**

160

Identify as per dwg & Stock Location: 219

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

N/02/10 ~~JD~~

MF
11-02-09

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Picklist Print

Friday, December 17, 2010 7:55:37 AM

Page 1

Work Order ID: 64792

Parent Item: D3296-041

Parent Item Name: Door Assembly



Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C05.10.14 Added step 14 KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-7 Hinge 14.0"		Manufactured	No			100	Each	6.0000	1	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST038				6					
					63596			6					
D3161-9 Hinge 17.0"		Manufactured	No			100	Each	4.0000	1	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST040				4					
					63344			4					
D3296-1 Door Panel		Manufactured	No			100	Each	1.0000	1	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST186				1					
					57975			1					
D3296-3 Door Panel		Manufactured	No			100	Each	10.0000	1	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST186				10					
					59639			10					

6
 11/02/07
 B65097 (4K)

6
 11/02/07
 65098 (6K)

6
 11/02/07
 B65083 (9K)

6
 11/02/07
 10

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 64792

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 6.00

Required Qty: 6.00

MS20470AD4-6

Purchased

No

100

Each

3,641.000

1



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

3030

116391

3030

ST320

611

114988

611

AN960JD6

NAS1149DN632

Purchased

No

140

Each

436.0000

1

6



Washer

Location

Loc Qty

Loc Code

ST347

436

104537

436

D2137

Manufactured

No

140

Each

12.0000

1



Decal - No Step

Location

Loc Qty

Loc Code

ST006

12

59395

2

62071

10

D2419

Manufactured

No

140

Each

21.0000

1

6



Handle

Location

Loc Qty

Loc Code

ST014

21

63423

21

Friday, December 17, 2010 7:55:37 AM

Shop Packet Print

Page 2

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Work Order ID: 64792

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 6.00

Required Qty: 6.00

D2462 Manufactured No

140 f

603.6009 0.3333 1.9998



Seal

Location

Loc Qty

Loc Code

ST404

603.6009

48530

603.6009

D2728-1 Manufactured No

140 Each

0.0000 0 0



Dart Logo label

MS20470AD4-4

Purchased No

140 Each

6,314.000 25



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

6314

112314

30

113368

92

116188

2556

116391

3636

Handwritten signature
12/16/09

3.333

Handwritten signature
12/16/09

250

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

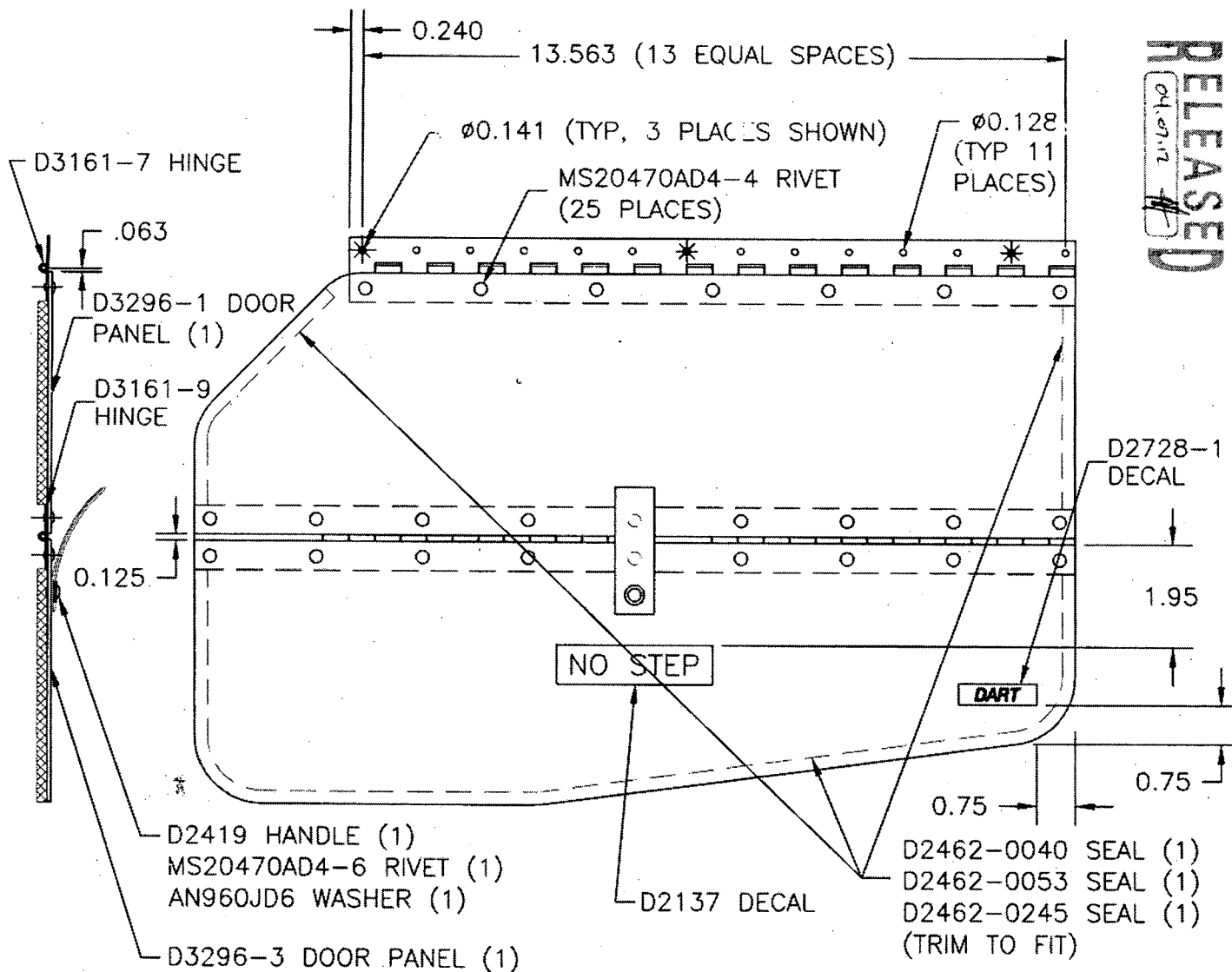
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D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.17

SHOP COPY
TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITH NOTICE
WORK ORDER
NO. 64792
28-12-17



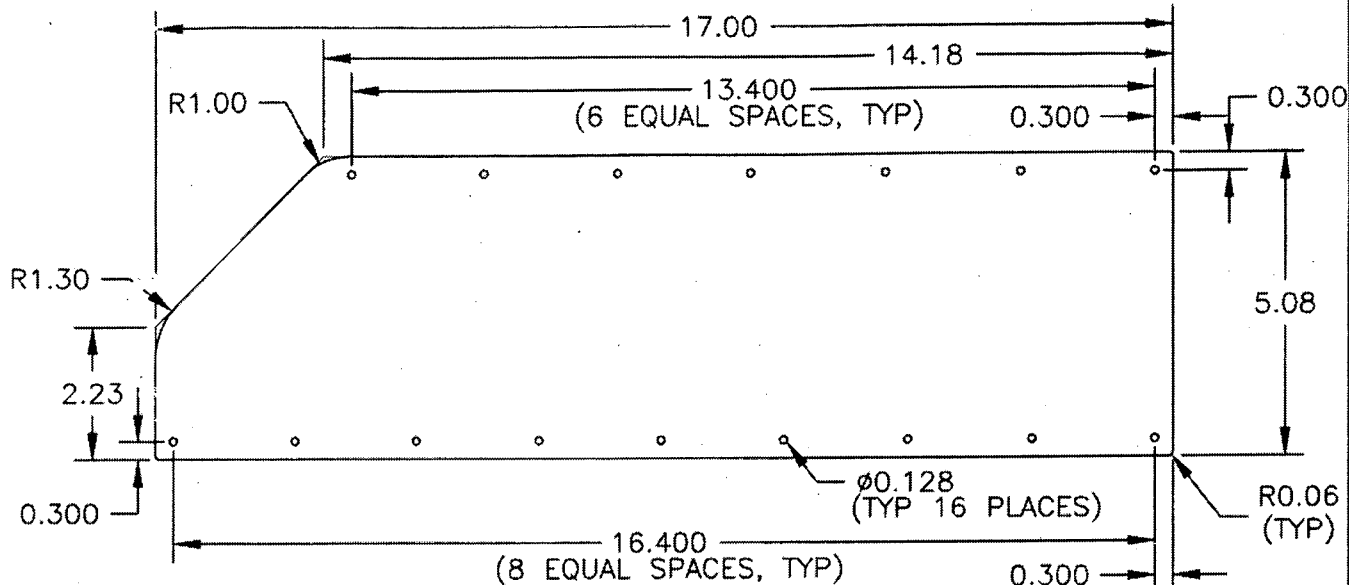
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
04.06.28	D3296	1 OF 2
	TITLE	SCALE
	DOOR ASSEMBLY	1:3
A	04.06.28	NEW ISSUE

26064792

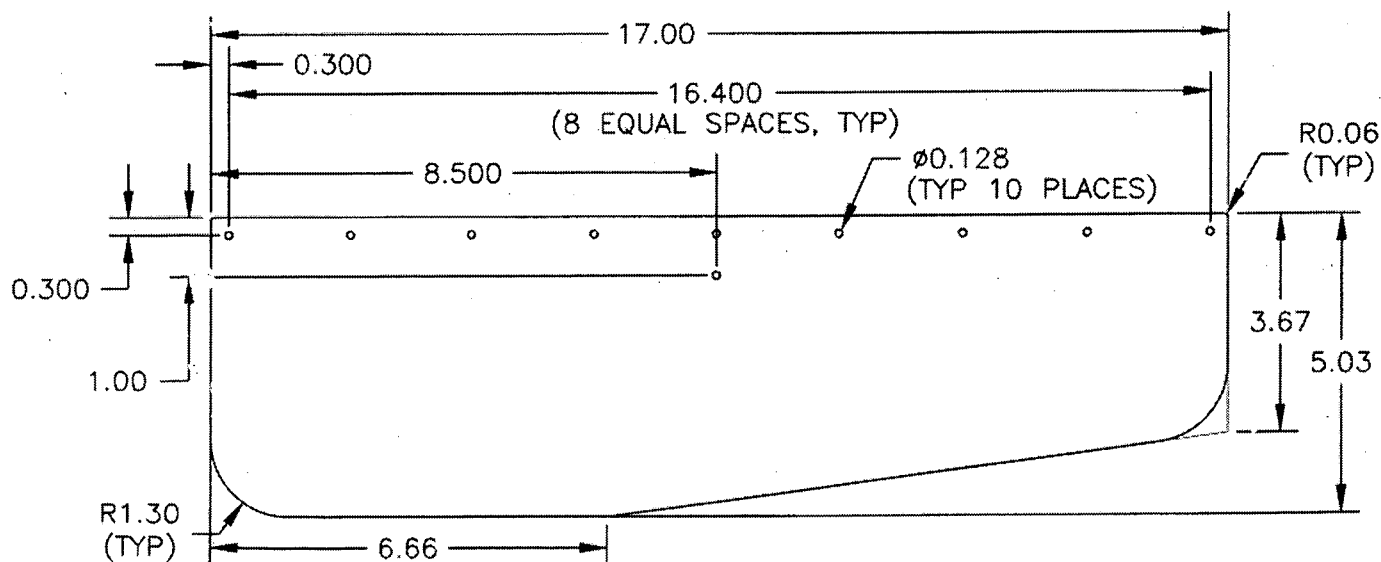
DART



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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